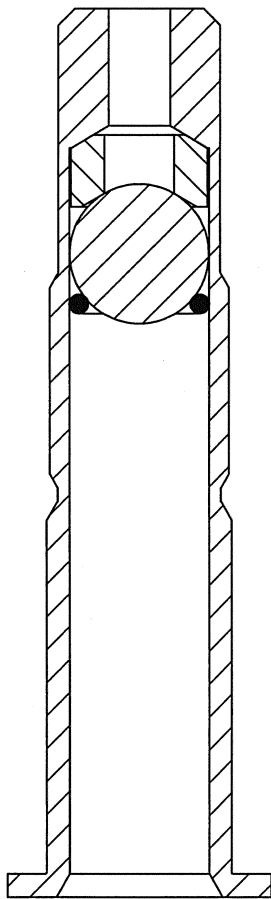
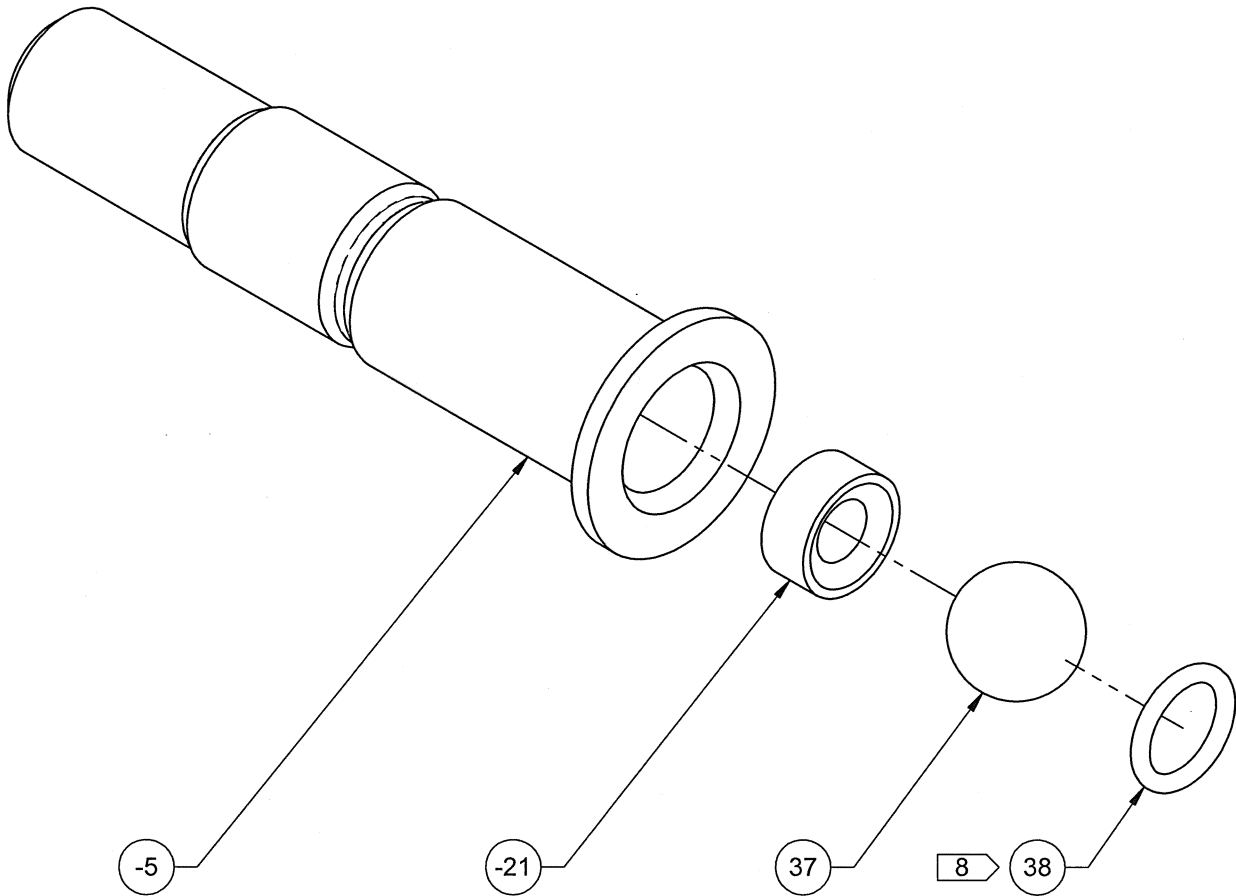


ITEM #	QTY	PART #	PART TITLE
-5	1	RB T101576-5	MANDREL
-21	1	RB T101576-21	PLUG
37	1	McMaster#9642K63 OR EQUIV.	440C SS BALL 3/4" DIA.
38	1	McMaster#2857T128 OR EQUIV.	VITON O-RING 3/32 THK. X 9/16" ID. X 3/4" OD.



(THIS VIEW IS SHOWN FOR REFERENCE ONLY)



**RB T101576-3 MANDREL ASSY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 38 THEN ASSEMBLE WITH ITEM -5 AND REMOVE EXCESS

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. H
MFG. APPR.	FK	<b>RB T101576</b>	SHEET 2 OF 11
APPROVED		TITLE	SCALE
		<b>BALANCE SET</b>	NTS
DATE <b>2019-08-20</b>		COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

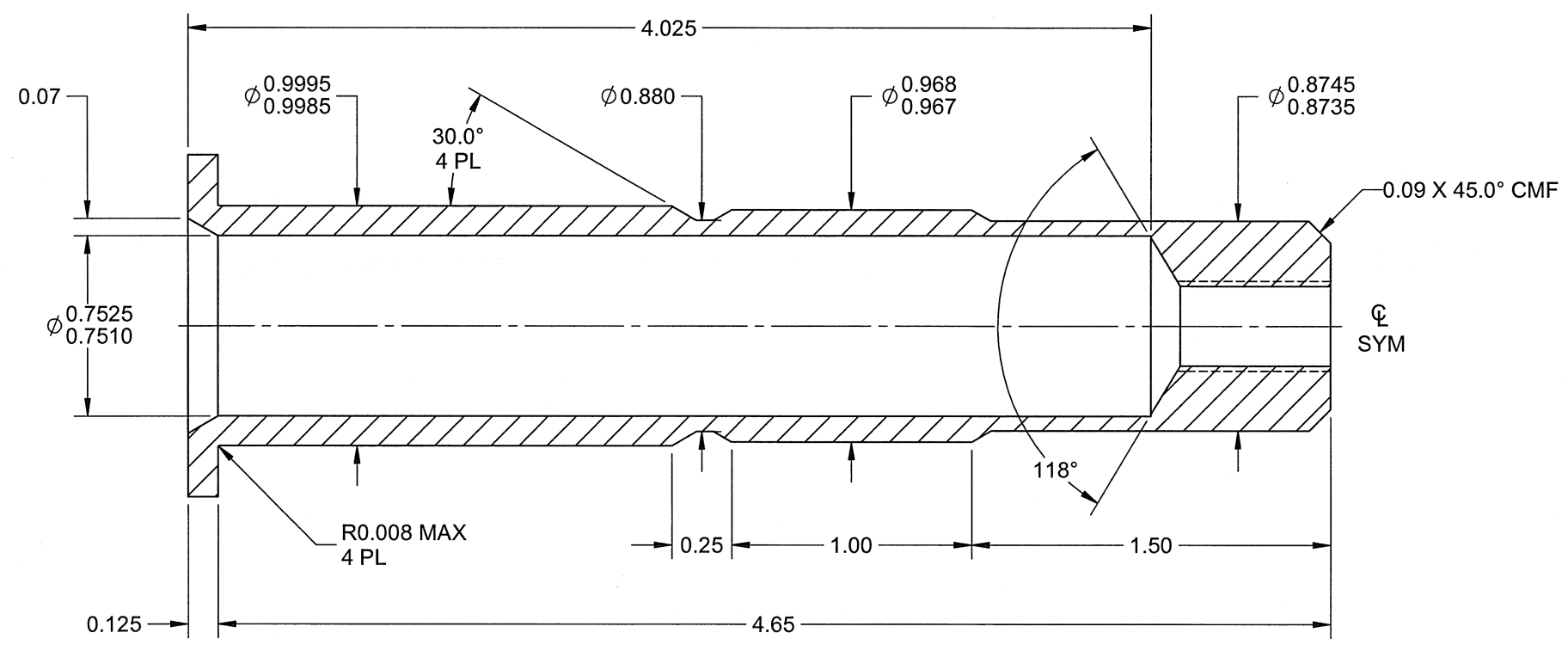
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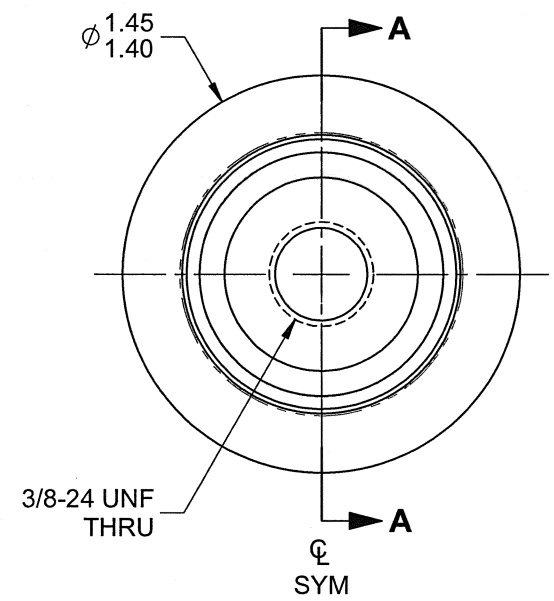
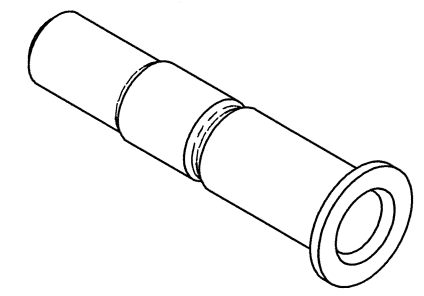
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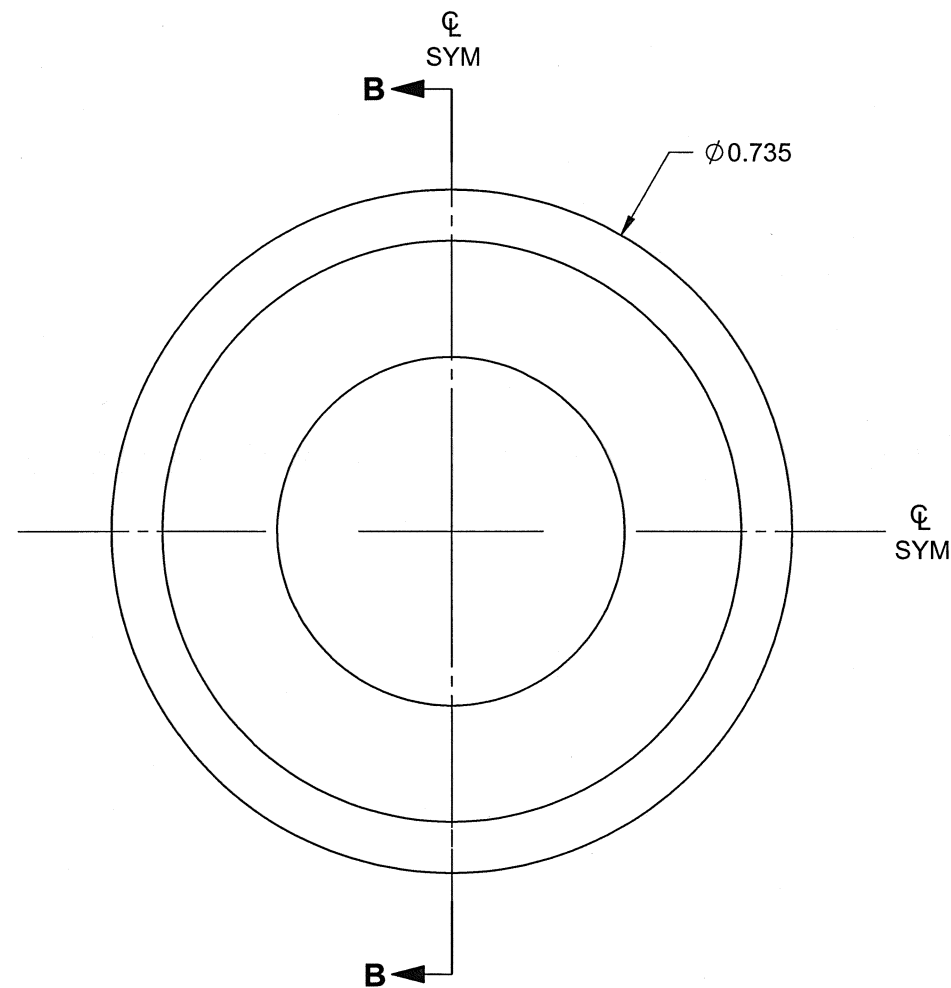
**SECTION A-A**



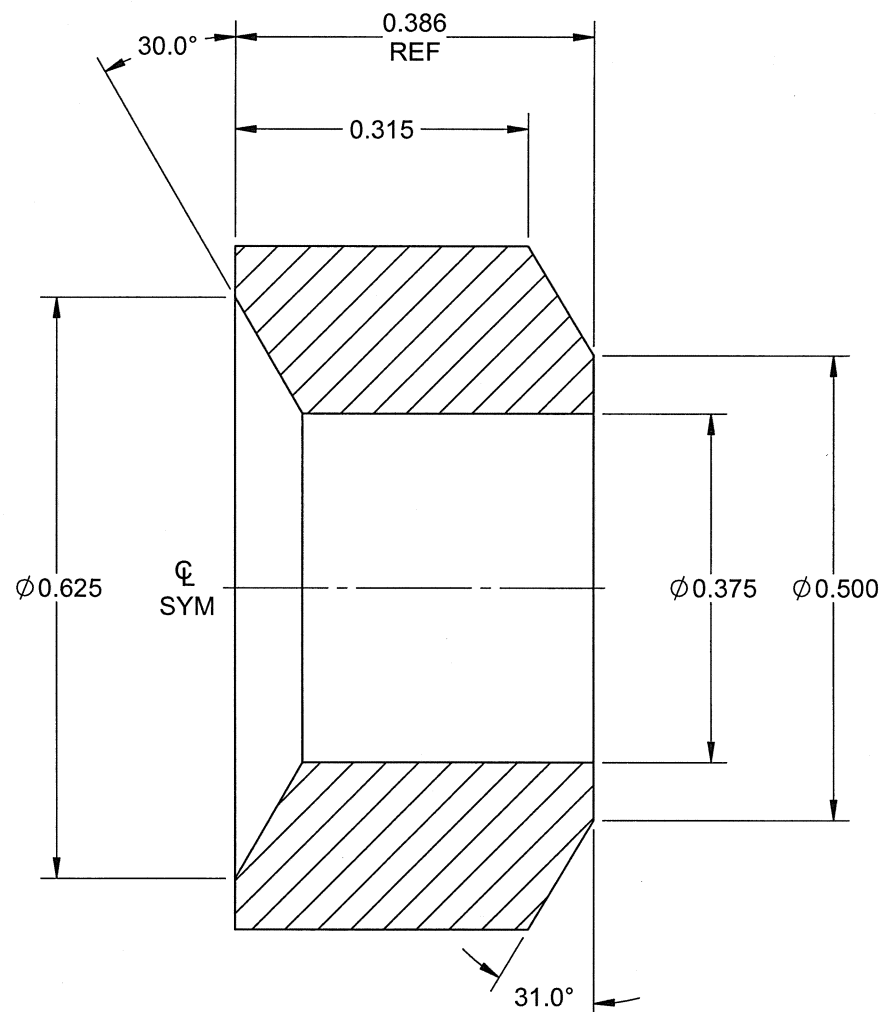
**RB T101576-5 MANDREL**

NOTES:  
1) MATERIAL: 303/304/316 STAINLESS STEEL  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A

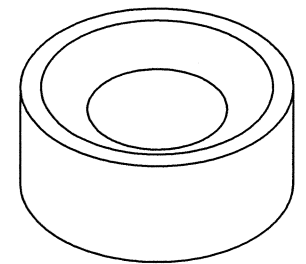
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. H
MFG. APPR.	FK	<b>RB T101576</b>	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		<b>BALANCE SET</b>	NTS
DATE <b>2019-08-20</b>		COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**RB T101576-21 PLUG**



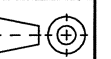
**SECTION B-B**



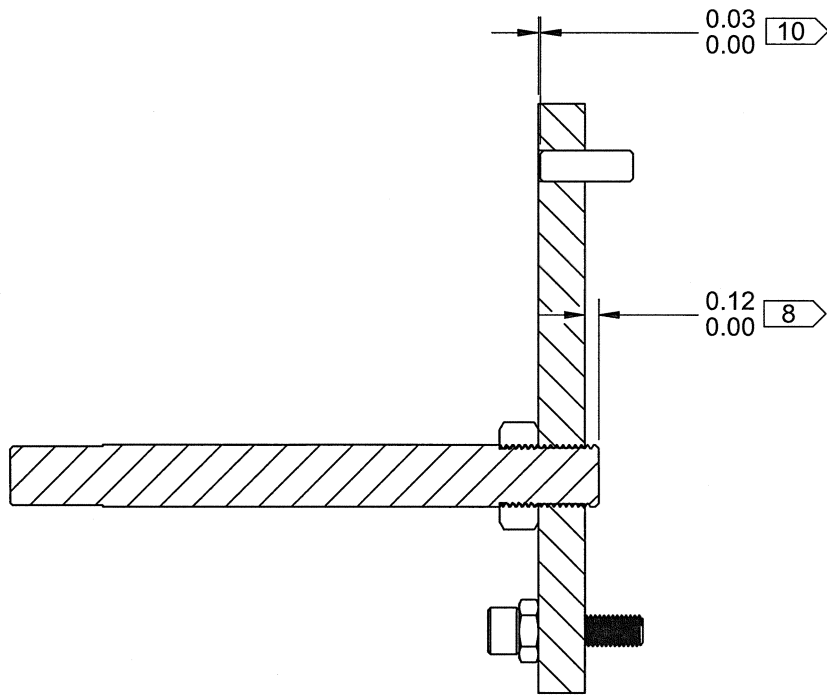
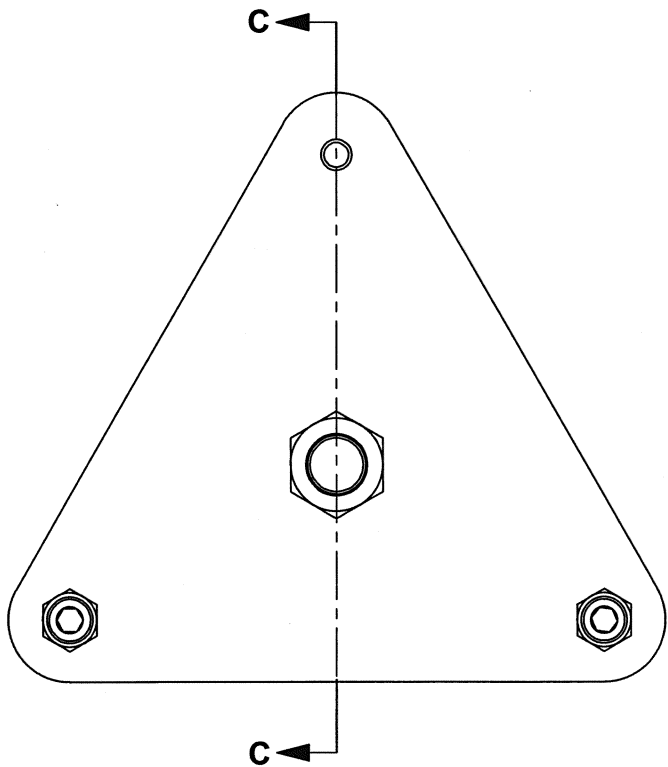
- NOTES:
- 1) MATERIAL: STAINLESS STEEL 440C
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. H  SHEET 4 OF 11	
DRAWN	KPT				
CHECKED	MBB	TOOL PART #	<b>RB T101576</b>		
MFG. APPR.	FK				
APPROVED		TITLE	<b>BALANCE SET</b>		
DATE					
2019-08-20					
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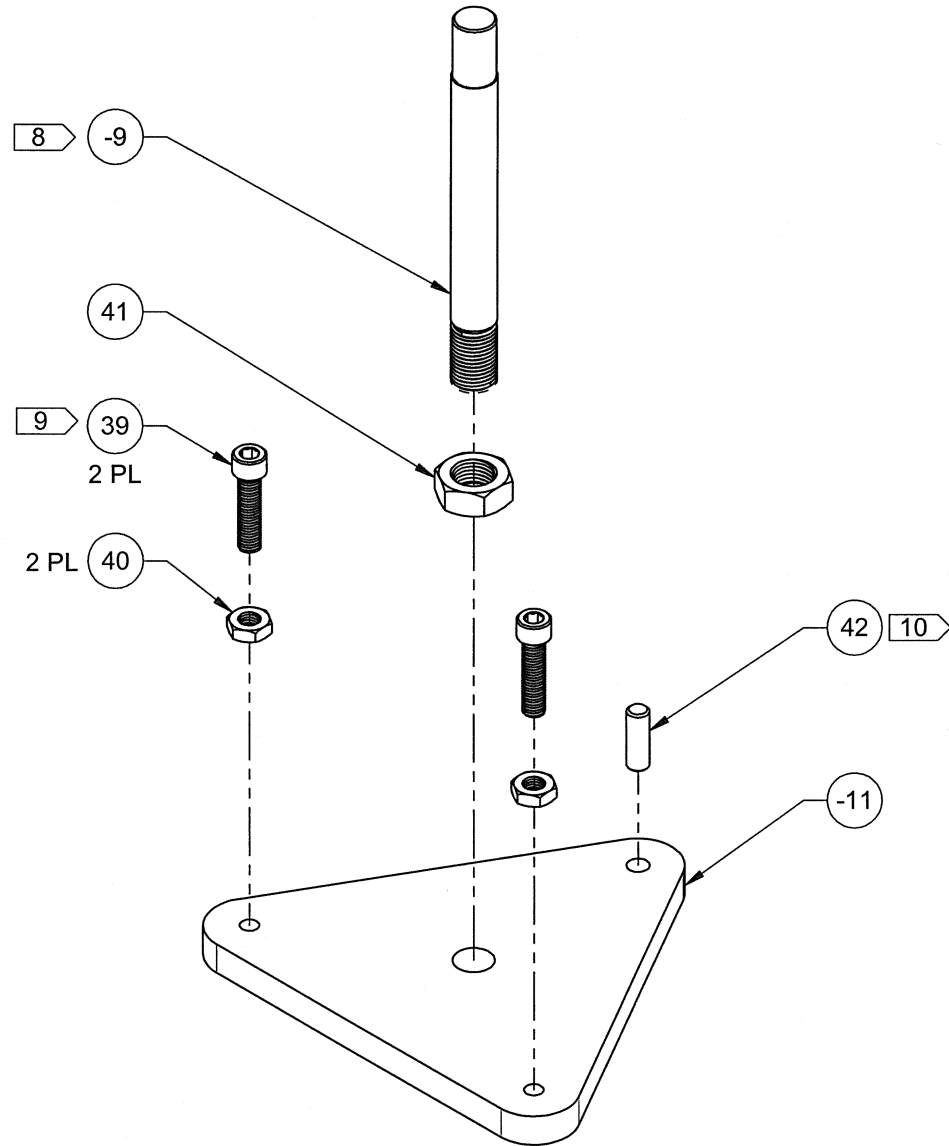
SCALE  
NTS



ITEM #	QTY	PART #	PART TITLE
-9	1	RB T101576-9	STAND
-11	1	RB T101576-11	PLATE
39	2	McMaster#92185A564 OR EQUIV.	SS SOCKET HEAD SCREW 1/4"-28 X 1" LG.
40	2	McMaster#94805A209 OR EQUIV.	SS HEX NUT 1/4"-28 X 5/32" HT.
41	1	McMaster#94805A224 OR EQUIV.	SS HEX NUT 1/2"-20 X 5/16" HT.
42	1	McMaster#98380A540 OR EQUIV.	SS DOWEL PIN 1/4" DIA. X 3/4" LG.





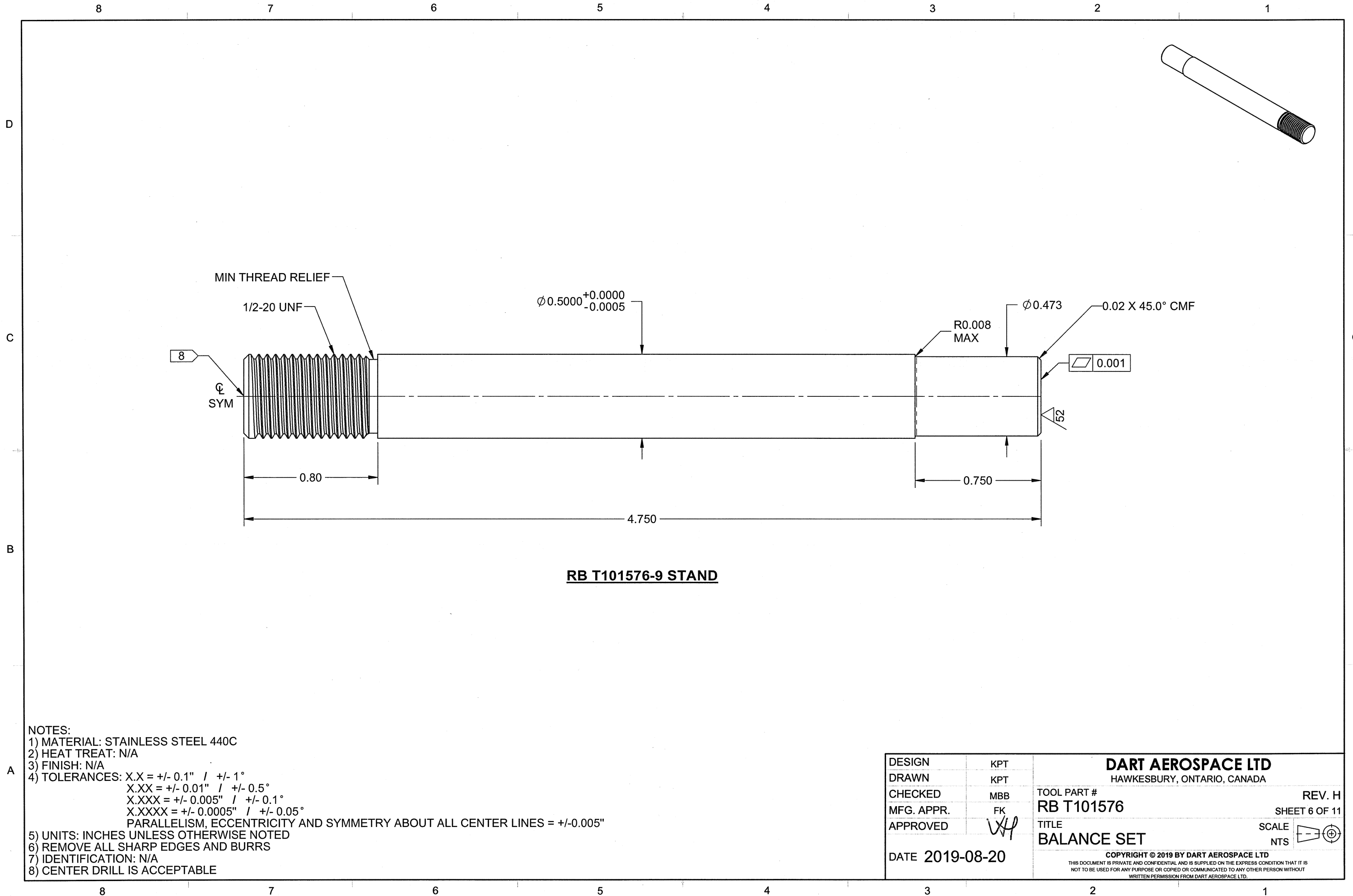
SECTION C-C



RB T101576-7 STAND ASSY

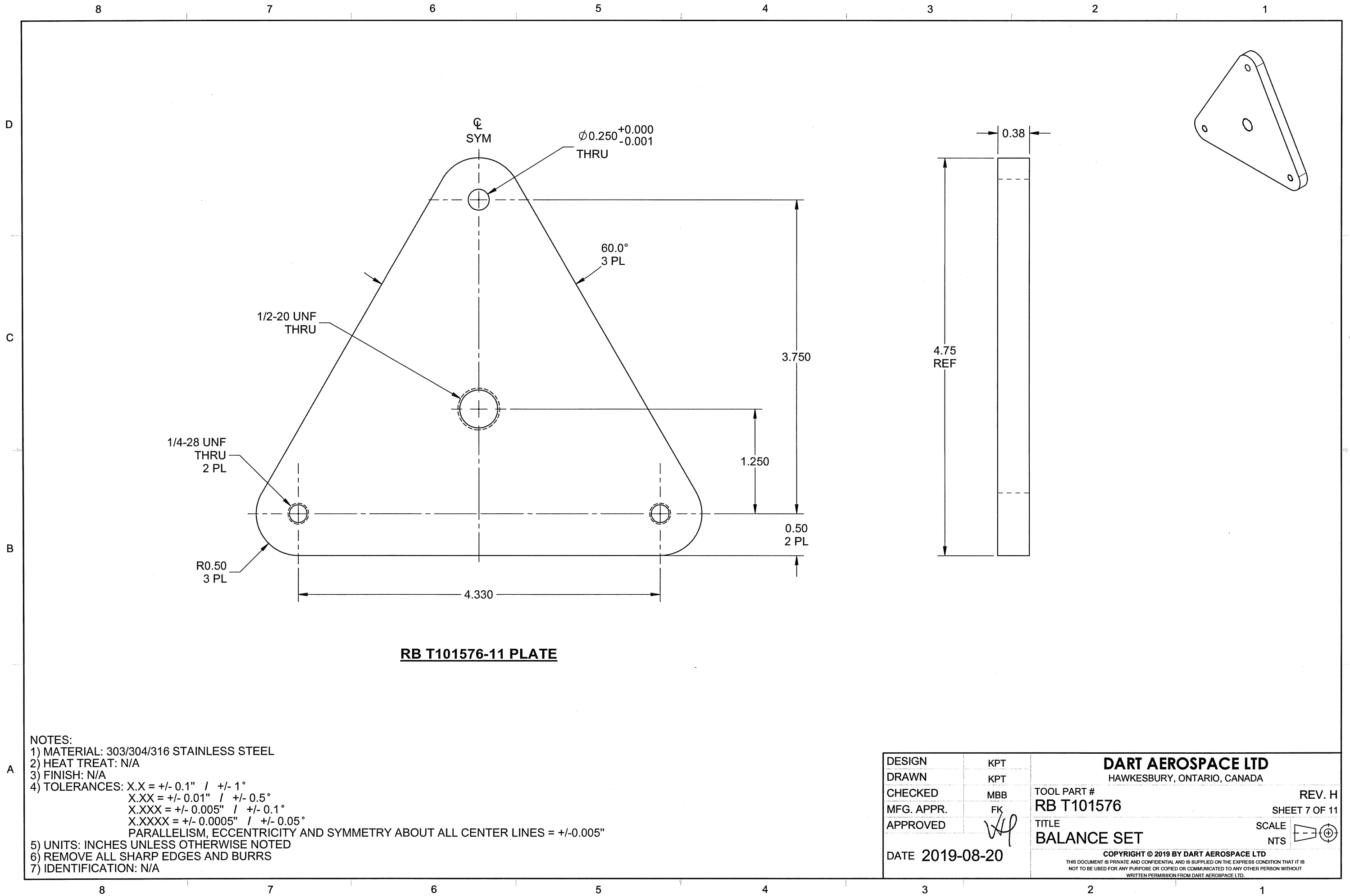
- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -9 THEN ASSEMBLE WITH ITEM 41 AND ITEM -11 AS SHOWN
  - 9) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM 39 THEN ASSEMBLE WITH ITEM 40 AND ITEM -11 AS SHOWN
  - 10) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 41 WITH ITEM -11 AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. H
MFG. APPR.	FK	RB T101576	SHEET 5 OF 11
APPROVED		TITLE	SCALE
		BALANCE SET	NTS 
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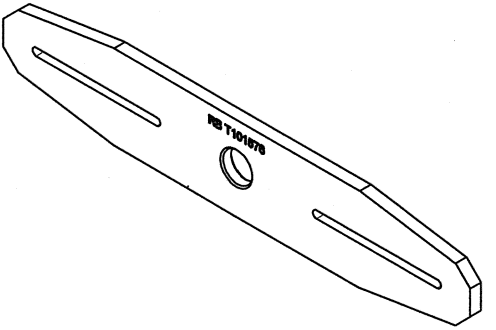
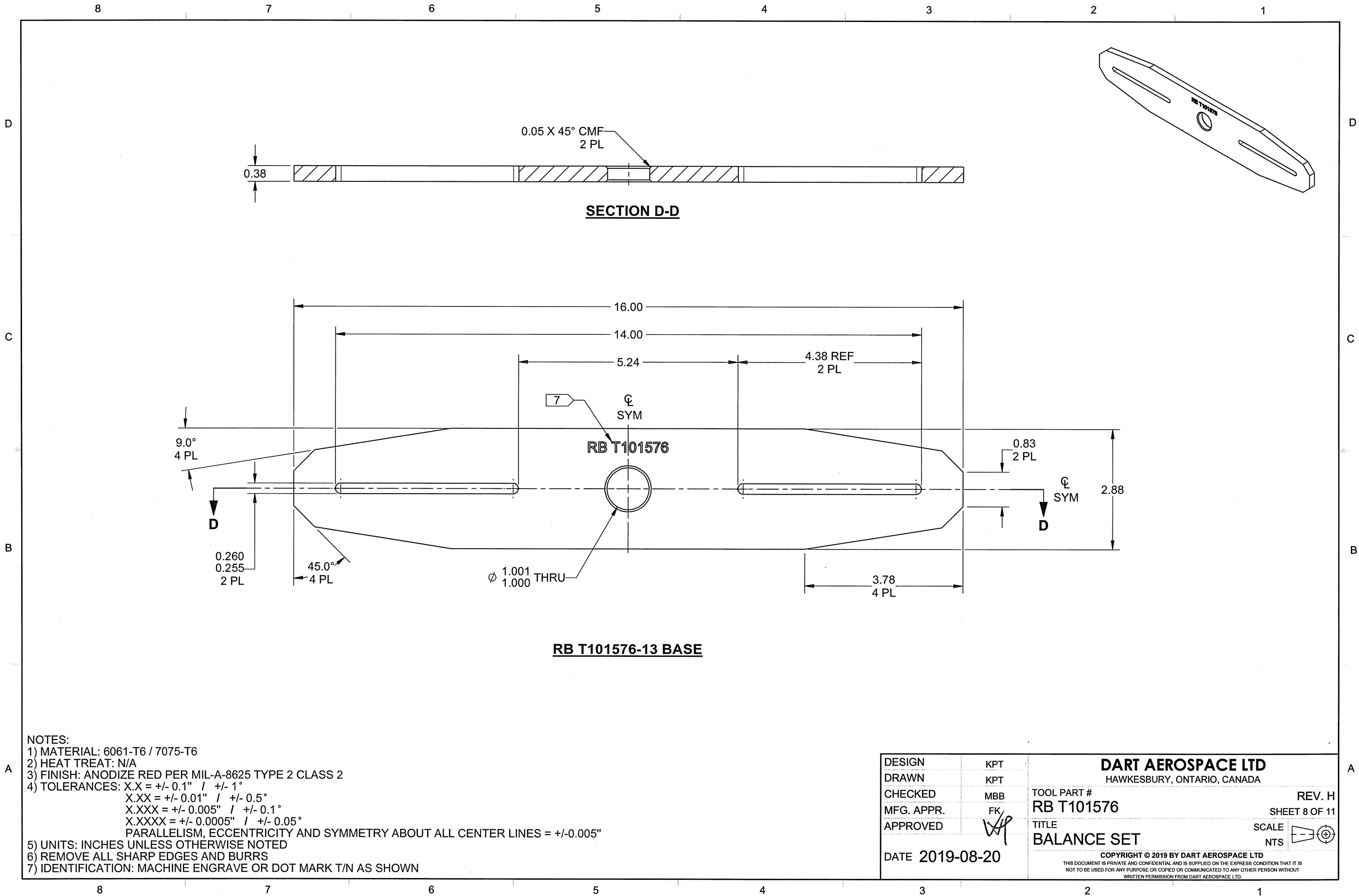
NOTES:  
1) MATERIAL: STAINLESS STEEL 440C  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A  
8) CENTER DRILL IS ACCEPTABLE

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. H
MFG. APPR.	FK	RB T101576	SHEET 6 OF 11
APPROVED	VHP	TITLE	SCALE
		BALANCE SET	NTS
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NOTES:  
1) MATERIAL: 303/304/316 STAINLESS STEEL  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. H
MFG. APPR.	FK	RB T101576	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DATE 2019-08-20		BALANCE SET	NTS 
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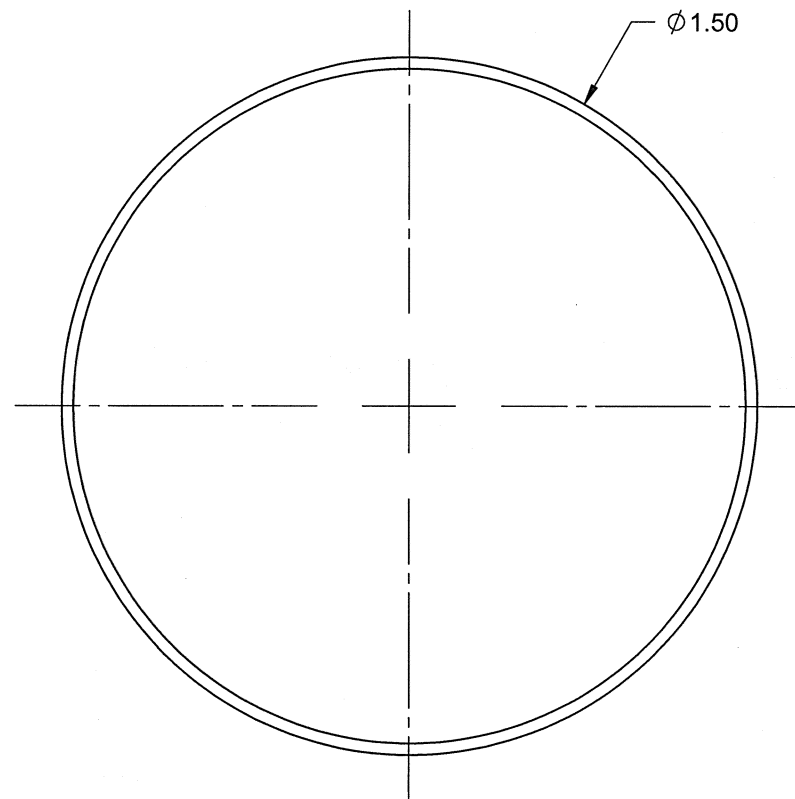
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**RB T101576-19 PLATE****NOTES:**

1) MATERIAL: 17-4PH-H900 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

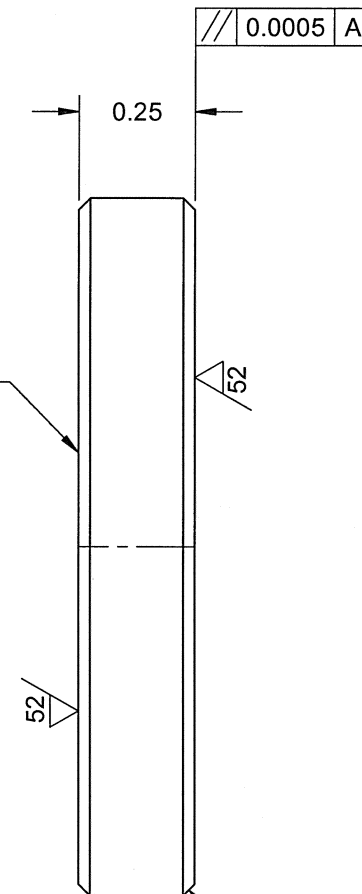
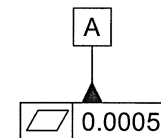
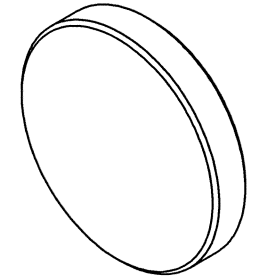
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

0.03 X 45.0° CMF  
2 PL

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NOTES:

1) MATERIAL: 17-4PH-H900 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. H
DRAWN	KPT			
CHECKED	MBB	TOOL PART # <b>RB T101576</b>	SHEET 9 OF 11	
MFG. APPR.	FK			
APPROVED		TITLE <b>BALANCE SET</b>	SCALE	
			NTS	
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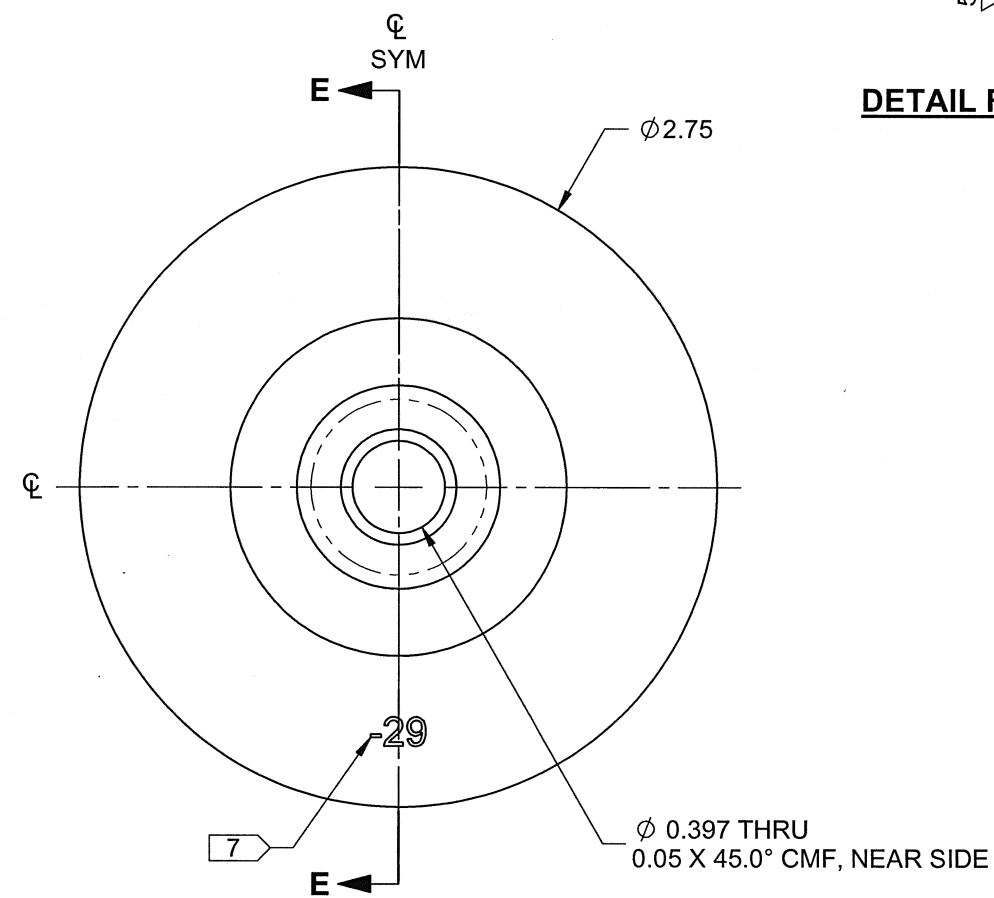
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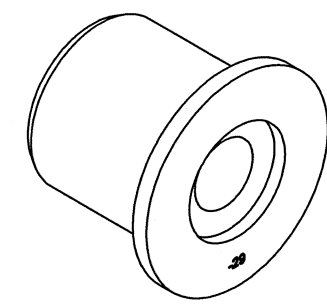
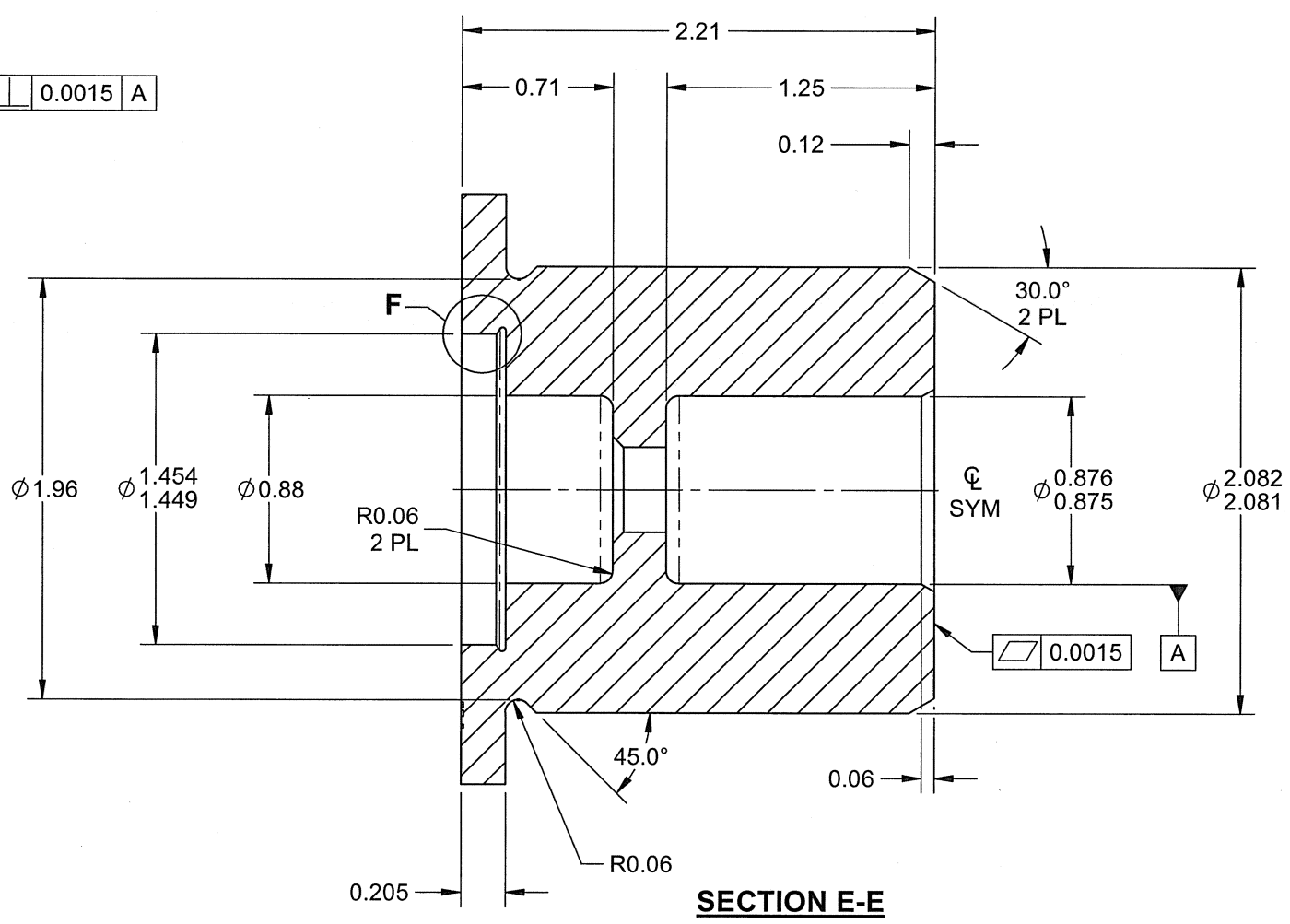
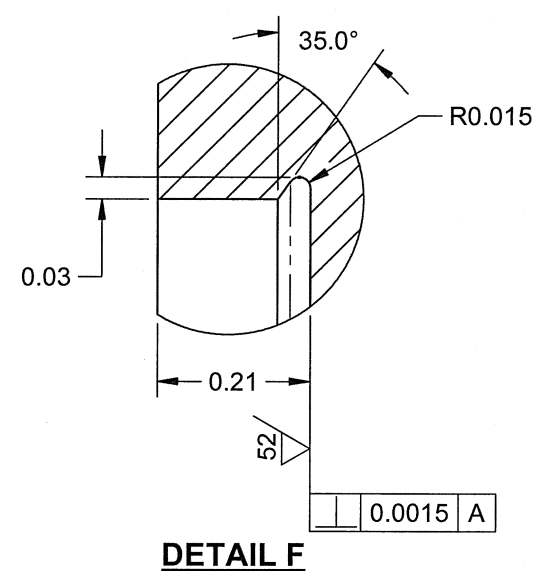
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**RB T101576-29 206 PLUG**





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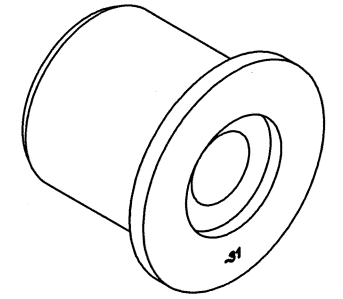
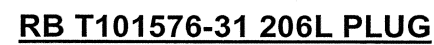
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- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK AS SHOWN

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. H
DRAWN	KPT			
CHECKED	MBB	TOOL PART #	SHEET 10 OF 11	
MFG. APPR.	FK	RB T101576		
APPROVED		TITLE	SCALE	
		BALANCE SET	NTS	
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DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. H
MFG. APPR.	FK	RB T101576	SHEET 11 OF 11
APPROVED		TITLE	SCALE
		BALANCE SET	NTS 
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